

Work Order ID 82370

March-29-12 3:12:32 PM

82370

PRELIMINARY ISSUE

12.04.08
ECN 12-586
Page 1

Item ID: D4628-3

Accept

N9000040100

Setup Start

NS1

Revision ID: ~~PRELIM~~

Item Name: Liner, Inboard

Stop ***NS2***

Start Date: 3/29/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/02/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4628

PAZ 2 Rev. A 12.04.08

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per dwg D4628

Prog rev: PAZ

Dwg rev: PAZ

2-Deburr as per dwg

B12-3-30

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

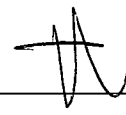
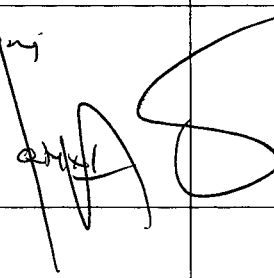
B12-3-30

Pto
S. Schell

W/O: 82310		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4628-3 PAR #: _____ Fault Category: Small PAB NCR: Yes No DQA: _____ Date: _____

Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/04	#130	Parts were scrapped at Assembly. R.C. improper installation Human error	S 12/04/04 057012	Remake As Per Drawing D4628-3 B 		-	S 12/04/04 057012	S 12/04/04

NOTE: Date & initial all entries

Work Order ID 82370

82370

Page 2

March-29-12 3:12:32 PM

Item ID: D4628-3
Revision ID: PRELIM
Item Name: Liner, Inboard

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 3/29/12 Start Qty: 1.00 ***1***
Required Date: 4/02/12 Req'd Qty: 1.00 ***1***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

POSITIVE RECALL

EFFECTIVE 12.03.29 AUTH W
RELEASED 12.03.29 DATE 12.03.29
ECN #12.528

Picklist Print

March-29-12 3:12:32 PM

Page 1

Work Order ID: 82370

Parent Item: D4628-3

Parent Item Name: Liner, Inboard

Start Date: 3/29/12

Required Date: 4/02/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA 12.03.29 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	796.2216	6.6	6.9473684			

Kydex steel grey

B12-3-30

Location

Loc Qty

Loc Code

therm

796.2215592

111807

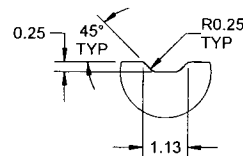
10.4896282

119476

785.731931

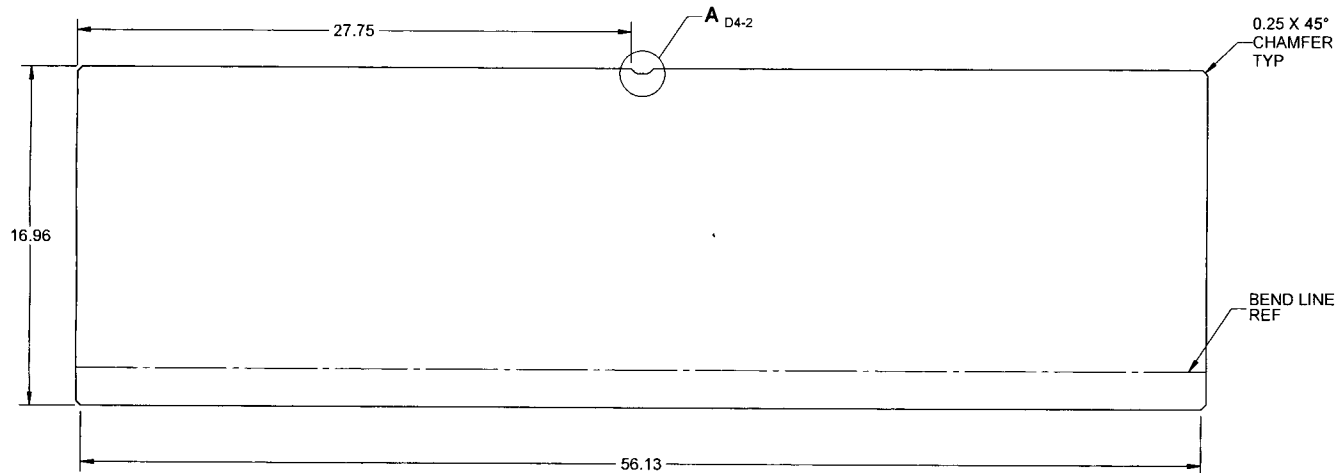
119476

①



DETAIL A CS-2
SCALE 2X

W/D 82370



D4628-3 LINER, INBOARD

D4628-3 LINER, INBOARD
FORMED DURING ASSY
REF ONLY

PRELIMINARY ISSUE

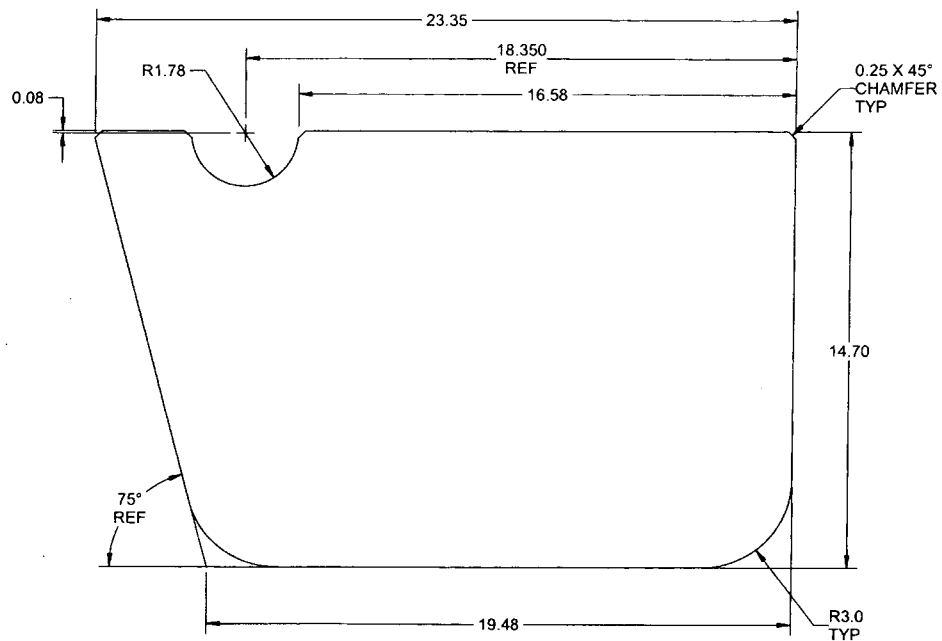
12.03.29

NOTES:

- 1) MATERIAL: KYDEX 6185 SHEET, VELOUR MATTE TEXTURE, WHITE (PREFERRED) OR STEEL GREY (ALTERNATE) COLOR, 0.080 THICK
REF. DART SPEC. MKYD6185S.080-P3-62000 OR MKYD6185S.080-P3-52068
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4628-3" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 3.35 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4628	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LINER	NTS
DATE	12.03.29	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4628-1 LINER, FACE

RELEASED
2012-04-04
WJ

NOTES:

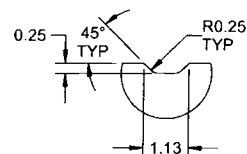
- 1) MATERIAL: KYDEX 6185 SHEET, VELOUR MATTE TEXTURE, WHITE (PREFERRED) OR STEEL GREY (ALTERNATE) COLOR, 0.080 THICK
REF: DART SPEC. MKYD6185S.080-P3-62000 OR MKYD6185S.080-P3-52068
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4628-1" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 1.07 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	MB	12.03.27
DESIGN			
DRAWN			
CHECKED	ASS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.03.27		

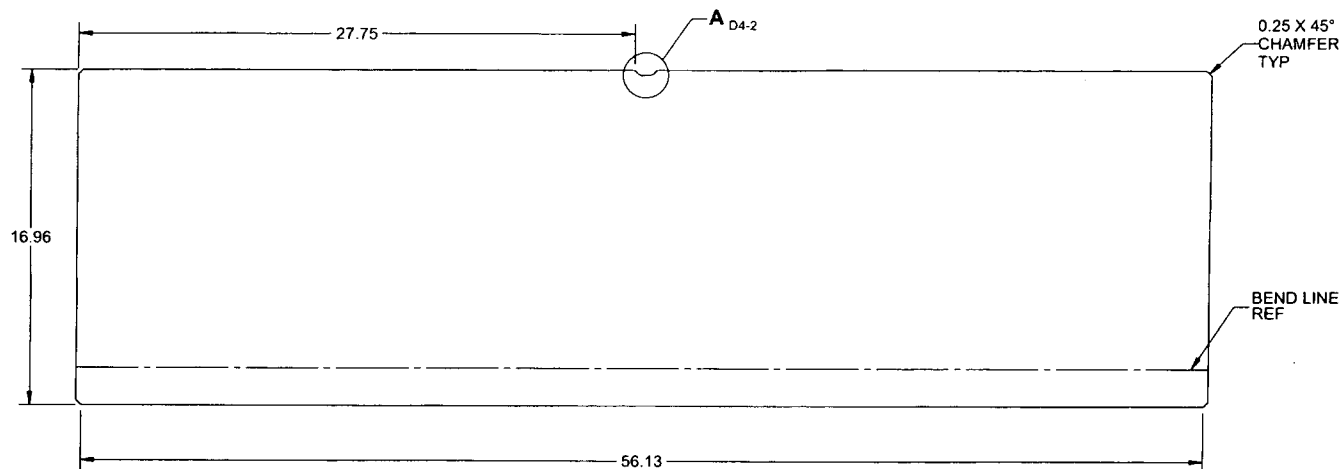
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4628** REV. A
SHEET 1 OF 5
TITLE **LINER** SCALE NTS

COPYRIGHT © 2012 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DETAIL A C5-2
SCALE 2X



D4628-3 LINER, INBOARD

D4628-3 LINER, INBOARD
FORMED DURING ASSY
REF ONLY

RELEASED
2012-04-06
MJP

NOTES:

- 1) MATERIAL: KYDEX 6185 SHEET, VELOUR MATTE TEXTURE, WHITE (PREFERRED) OR STEEL GREY (ALTERNATE) COLOR, 0.080 THICK
REF. DART SPEC. MKYD6185S.080-P3-62000 OR MKYD6185S.080-P3-52068
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4628-3" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 3.35 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D4628	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		LINER	NTS
DATE	12.03.27	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

16.99

56.13

0.25 X 45°
CHAMFER
TYP

BEND LINE
REF

0.080
REF

R2.9
REF

D4628-5 LINER, OUTBOARD

D4628-5 LINER, OUTBOARD
FORMED DURING ASSY
REF ONLY

RELEASED
2012-04-04

NOTES:

- 1) MATERIAL: KYDEX 6185 SHEET, VELOUR MATTE TEXTURE, WHITE (PREFERRED) OR STEEL GREY(ALTERNATE) COLOR, 0.080 THICK
REF. DART SPEC. MKYD6185S.080-P3-62000 OR MKYD6185S.080-P3-52068
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4628-5" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 3.35 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D4628	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		LINER	NTS
DATE	12.03.27	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

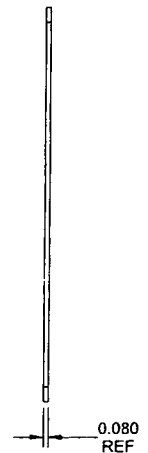
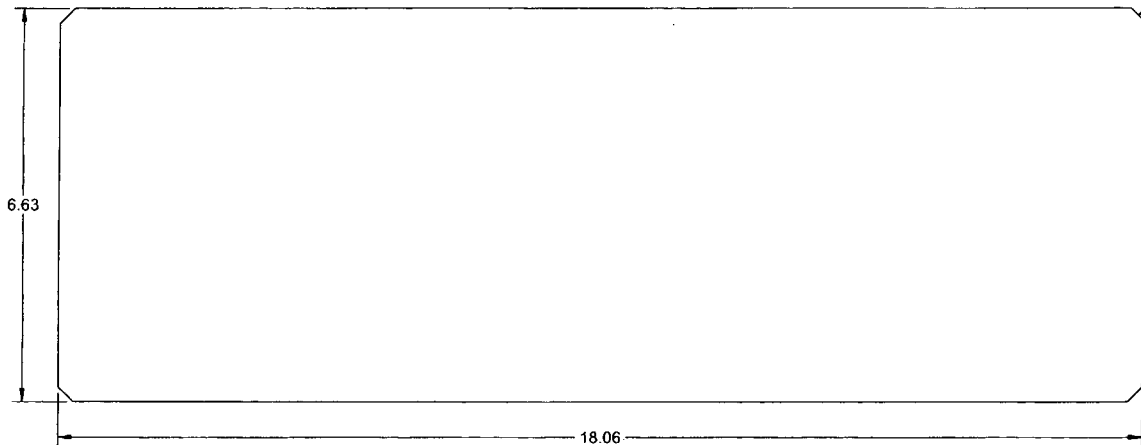
D

C

C

B

B



D4628-7 LINER, LID

RELEASED
2012-04-04

NOTES:

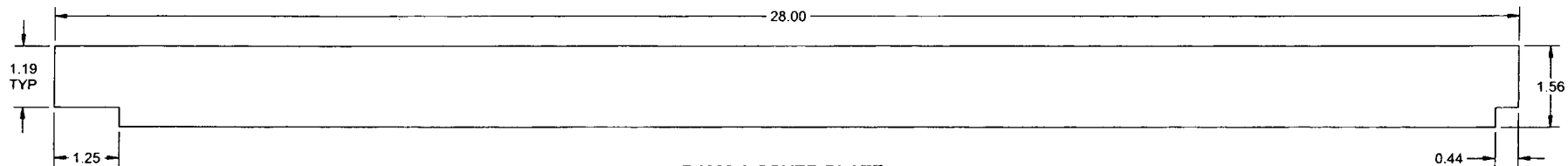
- 1) MATERIAL: KYDEX 6185 SHEET, VELOUR MATTE TEXTURE, WHITE (PREFERED) OR STEEL GREY(ALTERNATE) COLOR, 0.080 THICK
REF. DART SPEC. MKYD6185S.080-P3-62000 OR MKYD6185S.080-P3-52068
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4628-7" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 0.42 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>ASS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>ASS</i>	D4628	SHEET 4 OF 5
APPROVED	<i>ASS</i>	TITLE	SCALE
DE APPR.	<i>ASS</i>	LINER	NTS
DATE	12.03.27	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

A

A



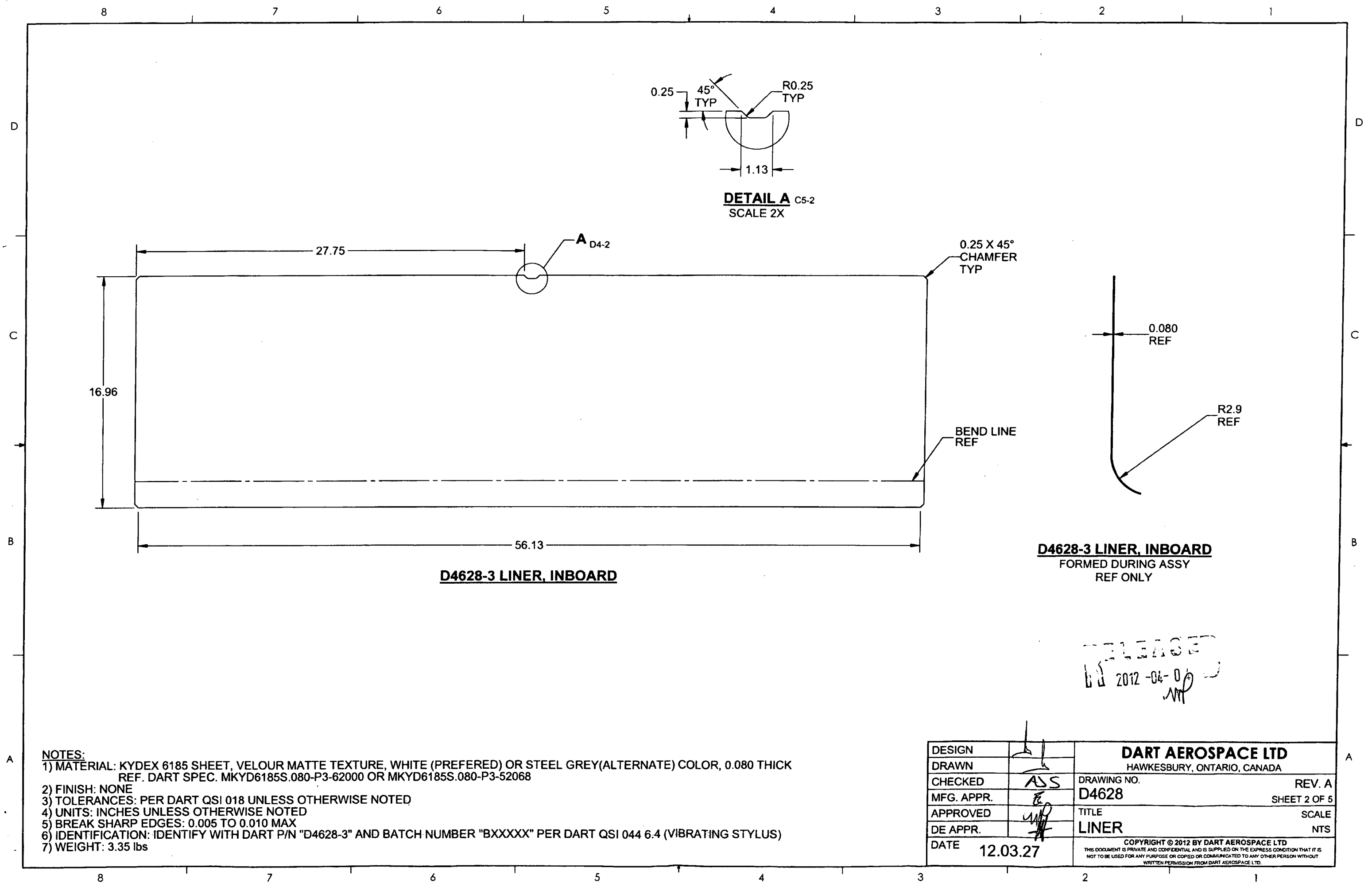
D4628-9 COVER PLATE

RELEASED
2012-04-04
MMP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO. D4628	REV. A
MFG. APPR.	E	SHEET 5 OF 5	
APPROVED	MMP	TITLE LINER	SCALE
DE APPR.		NTS	
DATE	12.03.27	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



DETAIL A C5-2
SCALE 2X

D4628-3 LINER, INBOARD

D4628-3 LINER, INBOARD
FORMED DURING ASSY
REF ONLY

- NOTES:**
- 1) MATERIAL: KYDEX 6185 SHEET, VELOUR MATTE TEXTURE, WHITE (PREFERED) OR STEEL GREY(ALTERNATE) COLOR, 0.080 THICK
REF. DART SPEC. MKYD6185S.080-P3-62000 OR MKYD6185S.080-P3-52068
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4628-3" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
 - 7) WEIGHT: 3.35 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	E	D4628	SHEET 2 OF 5
APPROVED	WJP	TITLE	SCALE
DE APPR.		LINER	NTS
DATE	12.03.27	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	